

PRODUCING PLANTS

Long Beach, Seattle, Antioch, and Jacksonville

FORMULA

Aridized Plaster Base Stucco	(S-5)	2000 lbs.
Bentonite Clay	(RM-G1)	15 lbs.
Aluminum Sulfate	(RM-P1)	4 lbs.
Hydrated Lime	(RM-P3)	6-1/4 lbs.
Wood Fiber	(RM-P5)	15-18 lbs.
Vermiculite	(RM-P13)	0-1.5 cu. ft.
Retarder		As required

NOTES

1. Aridized Plaster Base Stucco Blaine shall be 4700 - 5200.
2. Use high calcium lime only.
3. For gun application, 1 to 1-1/2 cubic feet of ^{plaster} ~~Zonelite~~ ^(RM-P5) per ton of stucco may be used to improve pumpability.

RAW MATERIAL HANDLING

1. Storage

All raw materials shall be stored in a cool, clean, dry area to prevent contamination and moisture pick-up.

2. Additive Screening

- a. Retarder shall be screened through a 30 mesh screen just prior to use.
- b. Do not use any additives which are lumpy without screening through a 30 mesh screen. Discard pre-mixed additives which have become lumpy upon storage.

3. Wood Fiber

Wood fiber shall be dried to a maximum free water content of 15% prior to use.

OPERATING SPECIFICATIONS:

1. Calibration

- a. Additive scales - The additive scales shall be calibrated and tested daily to assure proper functioning. Scales used for retarder shall be accurate to within ± 1 oz. of formula requirement. Additives used in less than 1/2 pound per batch shall be weighed on a gram balance to within ± 5 grams. Other additive scales shall be accurate to within ± 2 ozs. of formula requirement.
- b. Weigh Hopper - The stucco weigh hopper shall be calibrated and adjusted to insure batch weight uniformity within $\pm 2.0\%$. Once per month, minimum, the actual weigh hopper delivery shall be determined by weighing the total batch weight of five individual batches produced during normal operations. Maintain records of the test results.
- c. Bag Weights - Bag weights on individual sacker spouts shall be determined daily and records kept of the actual weights.

2. Mixing

The plaster shall be produced by dry mixing approximately one ton batches in the Ehram or Broughton plaster mixer. Mixing time shall be 2 minutes minimum.

3. Inspection

- a. Weigh Hopper - The weigh hopper gate (or bell) shall be checked daily for leakage. Check the gate during manufacture of the first batch produced and again as soon as the equipment warms up.
- b. Mixer Gate - The mixer gate shall be checked daily for leakage. Check the gate during manufacture of the first batch produced and again as soon as the equipment warms up.

PRODUCT SPECIFICATIONS:

Mortar Consistency (c.c.)	L.B., Antioch & Seattle Jacksonville and Selma	55 - 62 50 - 57
Normal Consistency ASTM (Near) (%)	L.B., Antioch & Seattle Jacksonville and Selma	50 - 56 47 - 53
Compressive Strength (psi)		1500 minimum
Flow Test, seconds	L.B., Antioch & Seattle Jacksonville and Selma	40 minimum 35 minimum
Wedge Test		
Peel		--
Sag		--